

## LOCTITE® Specialty Threadlocker Properties Chart

KEY FACTORS	KEY FEATURES	TYPICAL USE	PRODUCT	ITEM NUMBER	PACKAGE TYPE & SIZE	COLOR	VISCOSITY <sup>†</sup> (cP)	TORQUE <sup>‡</sup> IN.-LBS. (BREAK/PREVAL)	TEMP. RANGE	CURE SPEED (STEEL @ 25°C)	AGENCY APPROVALS	
SPECIALTY THREADLOCKERS	High Strength	High Temperature	High temperature applications	272™	27240 27270 27285	50 ml bottle 250 ml bottle 1 liter bottle	Red	9,500	200 / 220	-65°F to 450°F	Fixture – 1 hr. Full – 24 hrs.	CFIA Listed
		Ultra High Temperature	Ultra high temperature, high strength for 1/2" to 3/4" bolts	2620™	1138282	30 g syringe	Red	Paste	161 / 10	-65°F to 650°F	Fixture – 30 min. Full – 24 hrs.	CFIA Listed
		Enhanced Health & Safety	High strength	2700 NA™	1526123 1526565	50 ml bottle 250 ml bottle	Red	5,000 Thixotropic	300 / 265	-65°F to 300°F	Fixture – 5 min. Full – 24 hrs.	N/A
		High Lubricity (Large Bolts)	Large bolts >7/8": High lubricity delivers higher clamp load than 277™	2047™	1134607	50 ml bottle	Black	2,000 / 12,000 Thixotropic	375 / 80	-65°F to 300°F	Fixture – 90 min. Full – 24 hrs.	CFIA Listed
Plastic	Plastic Fasteners	For small metal and plastic fasteners and tamper-proofing	425™	42540	20 g bottle	Blue	80	4 / 2	-65°F to 180°F	Fixture – 1.5 min. Full – 24 hrs.	N/A	

## LOCTITE® MIL Spec Threadlocker Properties Chart

KEY FACTORS	TYPICAL USE	PRODUCT	ITEM NUMBER	PACKAGE TYPE & SIZE	COLOR	VISCOSITY <sup>†</sup> (cP)	TORQUE <sup>‡</sup> IN.-LBS. (BREAK/PREVAL)	TEMP. RANGE	CURE SPEED (STEEL @ 25°C)	AGENCY APPROVALS			
MIL SPEC THREADLOCKERS	Low Strength	Easy removal, small screws under 1/4"	222MS™	22205 22221 22231 22241	0.5 ml tube 10 ml bottle 50 ml bottle 250 ml bottle	Purple	1,200 / 5,000 Thixotropic	53 / 30	-65°F to 300°F	Fixture – 10 min. Full – 24 hrs.	MIL-S-46163A for existing designs, ASTM D-5363**, NSF P1, CFIA Listed		
			Medium Strength	Removable grade, 1/4" up to 3/4" bolts	242°	24205 24221 24231 24241 24243	0.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	Blue	1,200 / 5,000 Thixotropic	110 / 43	-65°F to 300°F	Fixture – 5 min. Full – 24 hrs.	MIL-S-46163A for existing designs, ASTM D-5363**, NSF/ANSI 61, NSF P1, ABS, CFIA Listed
					High Strength	High strength locking, up to 3/4" bolts	262™	26205 26221 26231 26241 26243	0.5 ml capsule 10 ml tube 50 ml bottle 250 ml bottle 1 liter bottle	Red	1,800 / 5,000 Thixotropic	189 / 275	-65°F to 300°F
	High Strength	High strength for fasteners up to 1" diameter					271™	27105 27121 27131 27141 27143	0.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	Red	500	250 / 275	-65°F to 300°F
			Wicking Grade	Permanent for large bolts >7/8"	277™	21434 27731 27741 27743	10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	Red	7,000	275 / 275	-65°F to 300°F	Fixture – 60 min. Full – 24 hrs.	MIL-S-46163A for existing designs, ASTM D-5363**
	Wicking Grade	Low strength wicking grade for preassembled fasteners under 1/4"			220™	37388 39186 22041	10 ml bottle 50 ml bottle 250 ml bottle	Blue	20	85 / 170	-65°F to 300°F	Fixture – 6 min. Full – 24 hrs.	MIL-S-46163A for existing designs, ASTM D-5363**, CFIA Listed
Wicking Grade			Medium/high strength, wicking grade for preassembled parts	290™	29005 29021 29031 29041 29043	0.5 ml tube 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	Green	25 / 55	90 / 260	-65°F to 300°F	Fixture – 20 min. Full – 24 hrs.	MIL-S-46163A for existing designs, ASTM D-5363**, NSF/ANSI 61, NSF P1, CFIA Listed	

## LOCTITE® Activator Properties Chart

LOCTITE® PRODUCT	ITEM	PACKAGE TYPE & SIZE	COLOR	VISCOSITY (cP)	BASE	ON-PART LIFE	DRY TIME	APPLICATION	AGENCY APPROVALS
SF 7088™ PRIMER	1069258	17 g stick	Teal	Semisolid	No solvent	30 days	None	Anaerobics	CFIA Listed
SF 7090™ ACTIVATOR	19368 12695	1 fl. oz. bottle 1 liter bottle	Dark Blue	17.5	No solvent	1 hour	None	Anaerobics	N/A
SF 7471™ PRIMER	19267 22477	1.75 fl. oz. glass bottle 4.5 oz. net wt. aerosol can 1 gallon can	Amber	2	Acetone/ Isopropanol	7 days	30 to 70 seconds	Anaerobics	MIL-S-22473E for existing designs, ASTM D-5363 for new designs, CFIA Listed
SF 7649™ PRIMER	19269 21347 21348	1.75 fl. oz. glass bottle 25 g net wt. aerosol can 4.5 oz. net wt. aerosol can 1 gallon can	Clear/ Green	2	Acetone	30 days	30 to 70 seconds	Anaerobics	MIL-S-22473E for existing designs, ASTM D-5363 for new designs, NSF/ANSI 61, NSF P1, CFIA Listed

ITEMS IN RED = Source's PICK or NEW

= Indicates Worldwide Availability

\*\* For new designs.  
† Brookfield RVT spindle 3.20 RPM/25 RPM.  
‡ M10 steel nuts and bolts.

PLEASE NOTE: A complete line of surface primers is available. Refer to the Surface Cleaning section, 129-132.

The Adhesive Sourcebook 2017: Your Source for LOCTITE® products for design, assembly, manufacturing and maintenance